

Work Order ID 127734

December-17-14 1:52:15 PM

127734

Page 1

Item ID: D3825-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly (Basket End, Lid)
 Start Date: 1/05/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/05/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MUS Date: 11-12-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3825	C
-------	---

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1- cut D3825-3 rib as per dwg D3825

2- drill hole (3/16") in D3825-3 using DT9822 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-1 spacer & D4021-9 bushing as per dwg D3825

A/R S.S. Rod Batch: 4131417

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

DAS

43

9-89

JUL 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 127734

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127734

Page 2

Item ID: D3825-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rib Assembly (Basket End, Lid)

Stop

NS2

Start Date: 1/05/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/05/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

(4)

DAS
24
9-89

JUL 28 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(4)

DAS
24
9-89

JUL 28 2015

150

Identify as per dwg & Stock Location: *WWA 04*

0.00

150

Packaging

Memo

0.00

Packaging

4x

DAS
43
9-89

JUL 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Accept

Setup Start

NS1

Item Name: Rib Assembly (Basket End, Lid)

Stop

NS2

Start Date: 1/05/15 **Start Qty:** 2.00

?

Cust Item ID:

Required Date: 1/05/15 **Req'd Qty:** 2.00

?

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start

NR1

Stop

NR2

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

SH 120150729

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:52:14 PM

Page 1

Work Order ID: 127734

127734

Parent Item: D3825-043

D3825-043

Parent Item Name: Rib Assembly (Basket End, Lid)

Start Date: 1/05/15

Required Date: 1/05/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.07.24 AS PER REV.B DD VERF:EC
REV:B 12.08.08 AS PER DWG REV.C DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2327-1*
Spacer Bushing

Manufactured	No	100	Each	23.0000	1	2	DAS 43 9-89	JUL 28 2015
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**

B131796 → 4x

Location

Loc Qty

Loc Code

WA004

23

107000

17

107115

6

✓ D4021-9*
Bushing

Manufactured	No	100	Each	154.0000	2	4	DAS 43 9-89	JUL 28 2015
--------------	----	-----	------	----------	---	---	-------------------	-------------

**

B129869 → 8x

Location

Loc Qty

Loc Code

WA004

154

116010

44

117495

1

120334

40

121536

20

121805

1

122601

10

123427

38

✓ M304TS0 750W.065
304 SQ Tube .75x.75x.065W

Purchased	No	100	f	860.5000	2.125	5	DAS 43 9-89	JUL 28 2015
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**

M132270 → 10 feet

Location

Loc Qty

Loc Code

WA004

860.5

125513

53.5

m126538

215

m128495

592

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
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Transport									
Unapproved									

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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

△C



RELEASE
2012-08-03

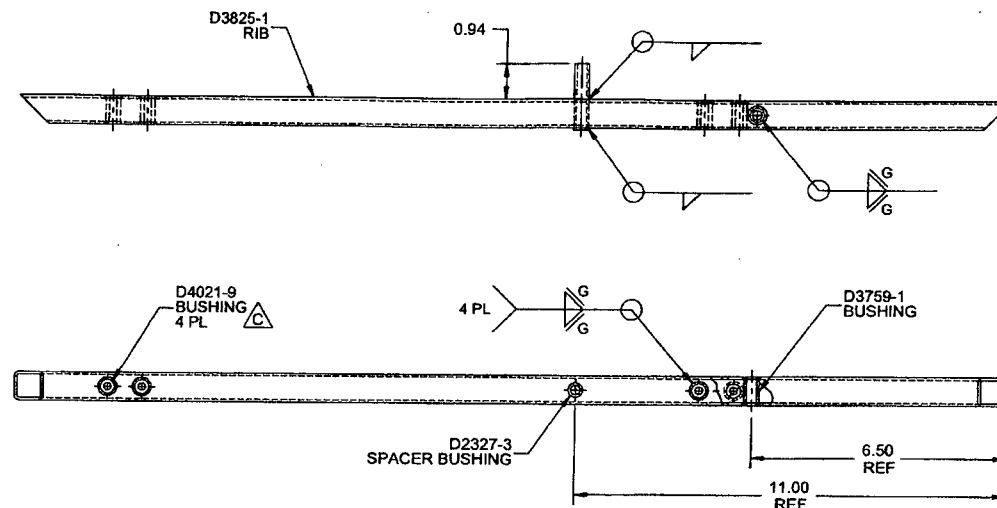
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3825-041 = 1.27 lbs; D3825-043 = 1.23 lbs
8) WELDING: PER DART QSI 004

UNCLASSIFIED COPY
SUPERSEDED DOCUMENT

[illegible]

127734 MJS
14-12-23

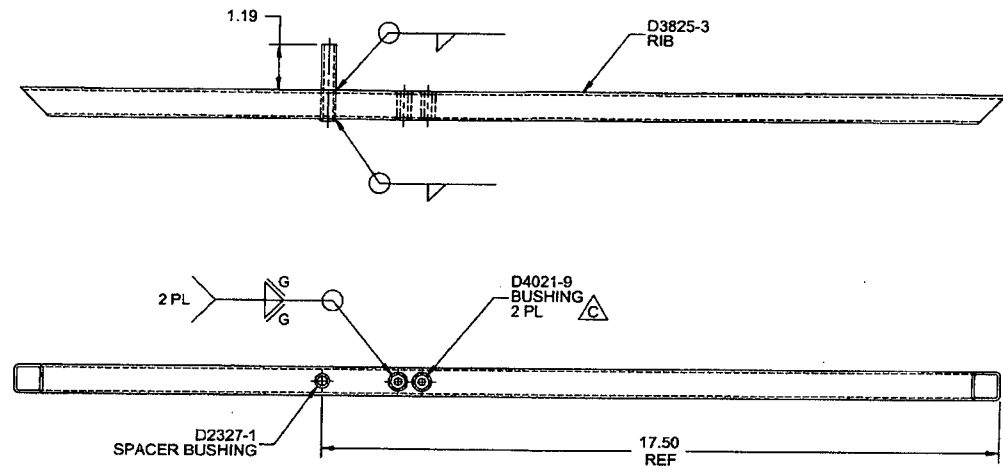
C	QTY(4) D4021-8 ON -041 AND QTY(2) D4021-9 ON -043 WERE D3750-1 CORRECTED DM (2N 63-1) WAS 14.875. REASON FOR CHG: AN3 SIZE BOLTS REQ'D IN THOSE LOCATIONS.	MB	12.07.18
B	QTY(5) FOR D3750-1 WAS QTY(1): AFFECTS D3825-041/-1 (2N5 D31-1, C-2, C3-2, D4-4, C6-4, C4-4, C3-4). ADDED REASON: PART10-S0. D3825-043-S.	MB	12.05.11
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3825	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NT
DATE	12.07.18	COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED TO YOU ON THE BASIS OF CONFIDENTIALITY. IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER THAN THE PURPOSE FOR WHICH IT WAS ISSUED.	



D3825-041 RIB ASSY (BASKET END)

RELEASED
2012-03-03
JMP

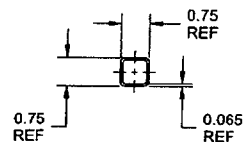
DESIGN	11	DART AEROSPACE LTD	
DRAWN	11	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D3825	REV. C
MFG. APPR.	AS	SHEET 2 OF 4	
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	RIB ASSY (BASKET END)	NTS
DATE	12.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D3825-043 RIB ASSY (BASKET END, LID)

RELEASED
2012-08-03
WJP

DESIGN	<i>L</i>	DART AEROSPACE LTD	
DRAWN	<i>L</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO. D3825	REV. C
MFG. APPR.	<i>AP</i>	SHEET 3 OF 4	
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>WJP</i>	RIB ASSY (BASKET END)	NTS
DATE	12.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



0.75 X 45° CHAMFER TYP

0.375

0.625

$\phi 0.375^{+0.020}_{-0.000}$ THRU

$\phi 0.49 \times 100^\circ$ CSK
2 PL, ON BOTH SIDES

15.508

17.500

25.50

$\phi 0.375^{+0.020}_{-0.000}$ THRU

$\triangle C$

RELEASE
2012-08-03

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.16 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3825	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE		COPYRIGHT © 2008 BY DART AEROSPACE LTD THE DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
		12.07.18	